

# Work Order ID 58596

Wednesday, May 12, 2010 8:57:49 AM

Page 1

Item ID: D3201-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 5/6/2010 Start Qty: 17.00



Cust Item ID:

Required Date: 5/6/2010 Req'd Qty: 17.00



Customer:

Reference:

Approvals:

Process Plan: mk

Date: 10-5-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3201

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3201

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

Deburr if necessary

7624 .040

AB 10-5-12

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

AB 10-5-12

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Swalston

counted  
100

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr Stack

u/45

140



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

20 BR 10-5-13.

150



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

u 10/05/13

20 0

W/O:		WORK ORDER CHANGES						
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg &amp; Stock Location: 44

0.00



Packaging

Memo

0.00

Packaging

10-5-13

20-SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/13

mf  
10-5-13

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, May 12, 2010 8:57:49 AM

Page 1

Work Order ID: 58596



Parent Item: D3201-1



Parent Item Name: Doubler

Start Date: 5/6/2010

Required Date: 5/6/2010

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM  
IPP Rev:B Now on Waterjet 06-08-14 JLM

Start Qty: 17.00

Required Qty: 17.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	499.7000	0.276	5.6		



2024-T3 .040 sheet



1310-5-12

Location

Loc Qty

Loc Code

MAT	96	
114415	96	
MAT22	403.7	
110305	136.7	
111786	15.5	
112291	32	
112331	64	
113162	155.5	

\_\_\_\_\_  
\_\_\_\_\_  
110305  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

20

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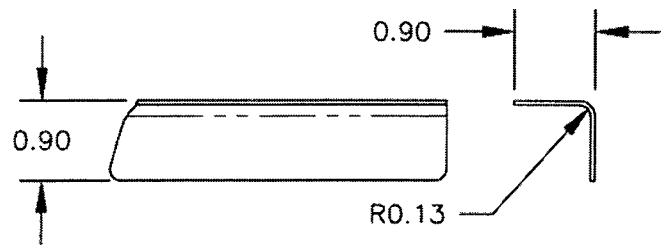
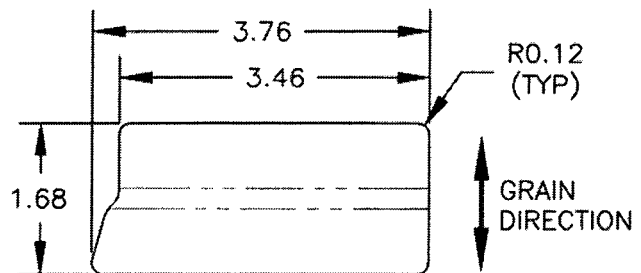
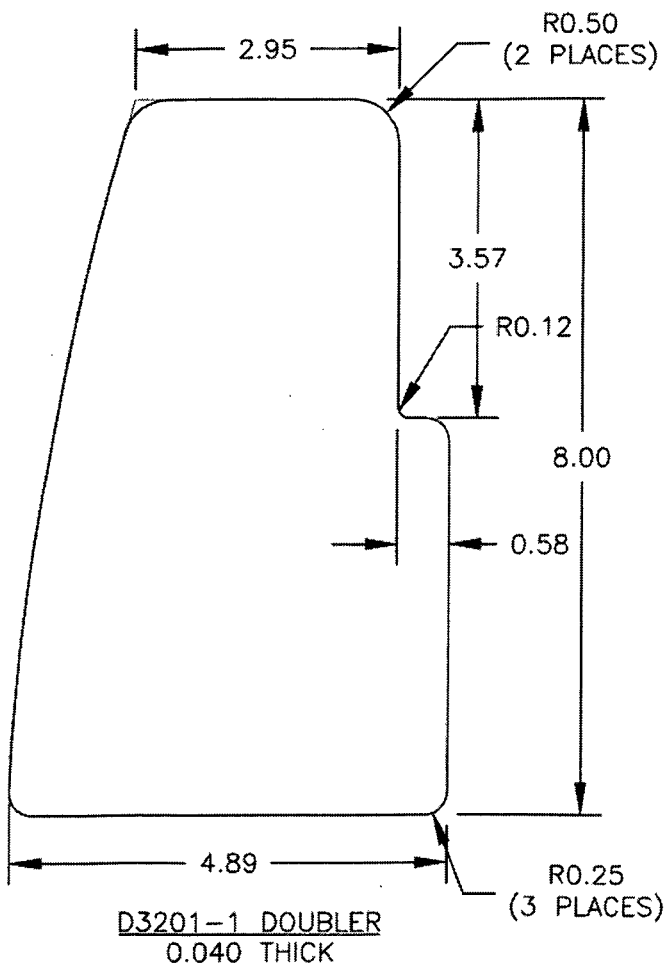
**NOTE:** Date & initial all entries



DESIGN	<i>#</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3201	SHEET 1 OF 1
DATE	03.11.03	TITLE	DOUBLER	SCALE	1:2
A	03.08.07	NEW ISSUE			
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4			

RELEASED  
03.11.14

# 58596



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)  
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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